

Fig 1

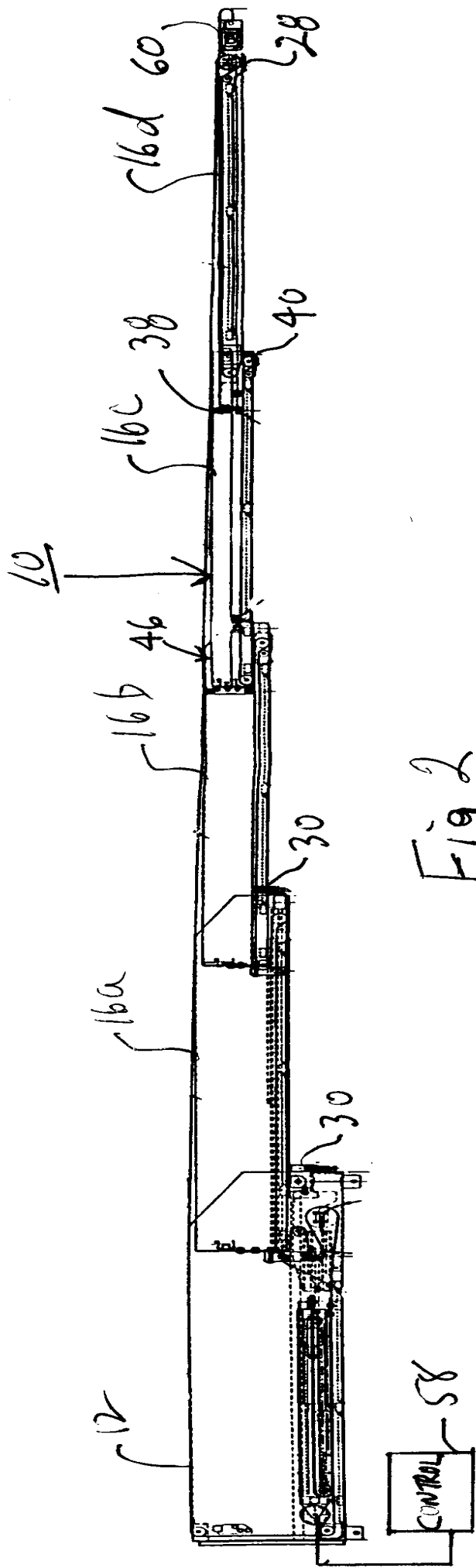


Fig 2

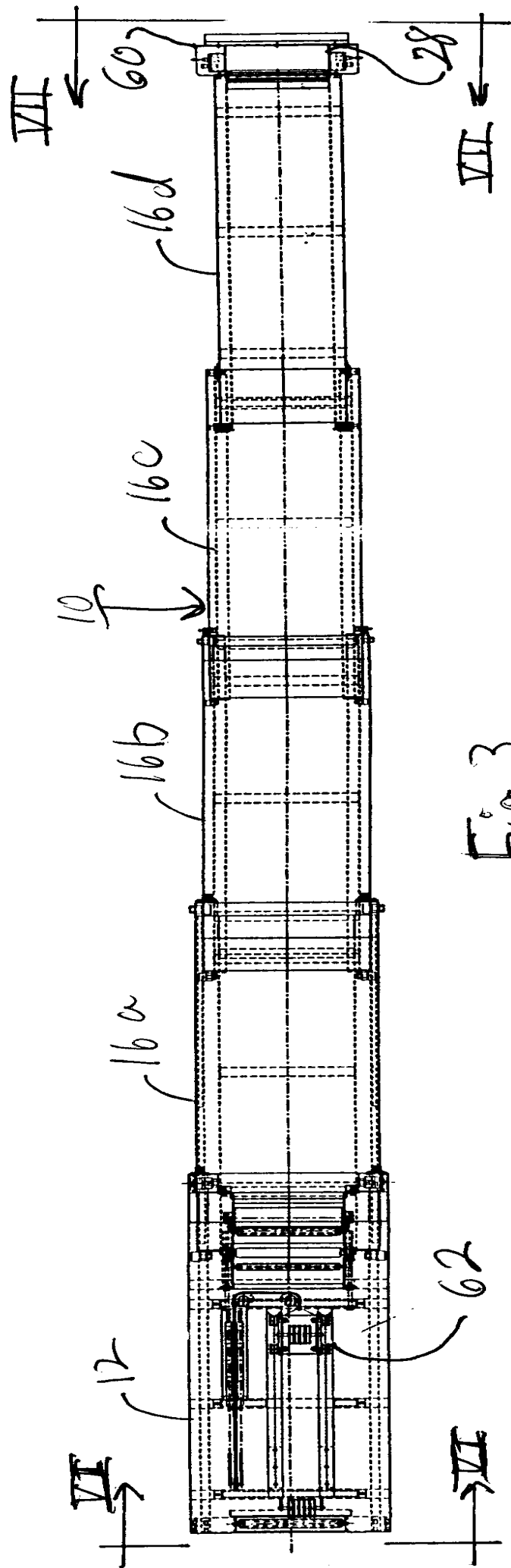
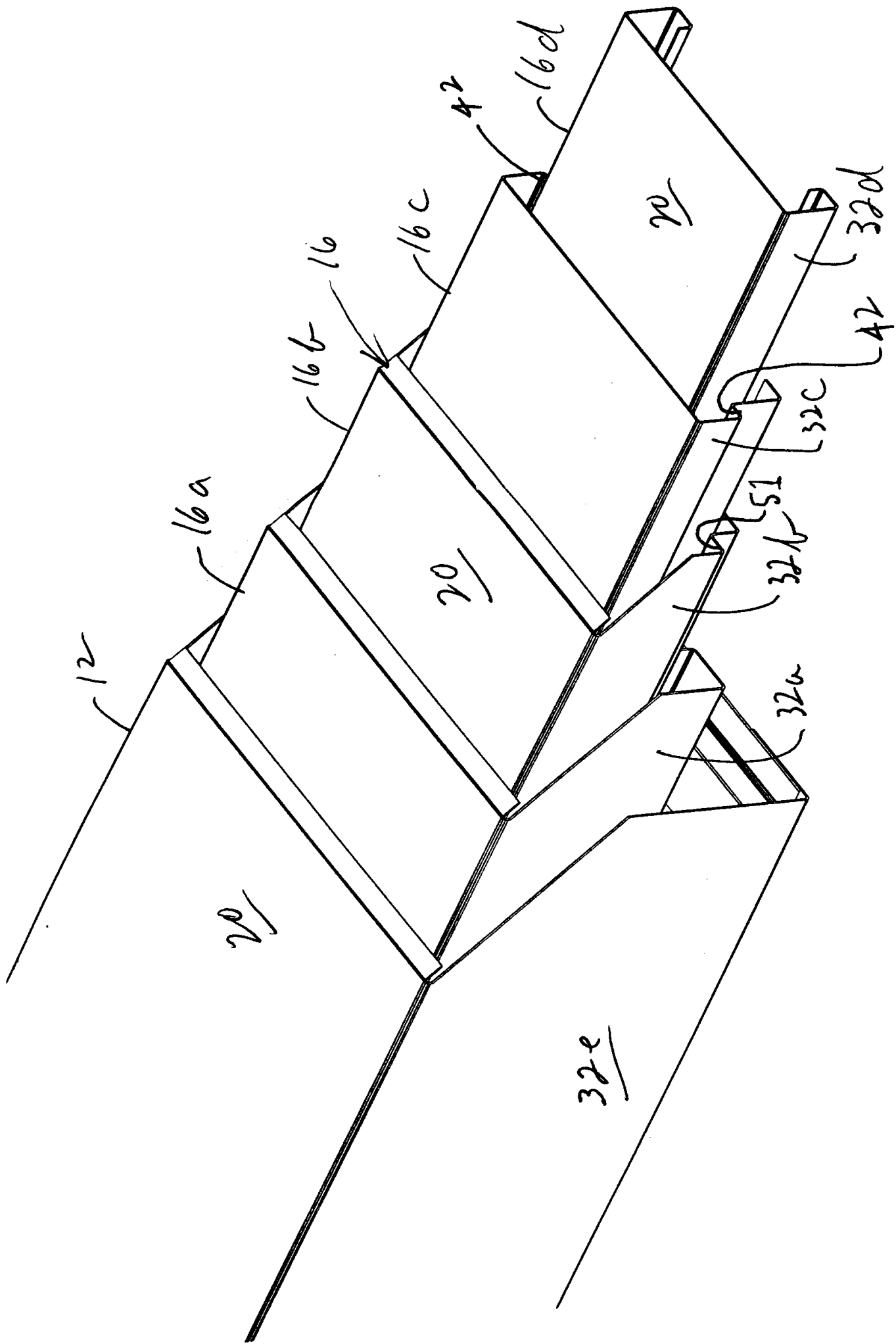


Fig 3



115

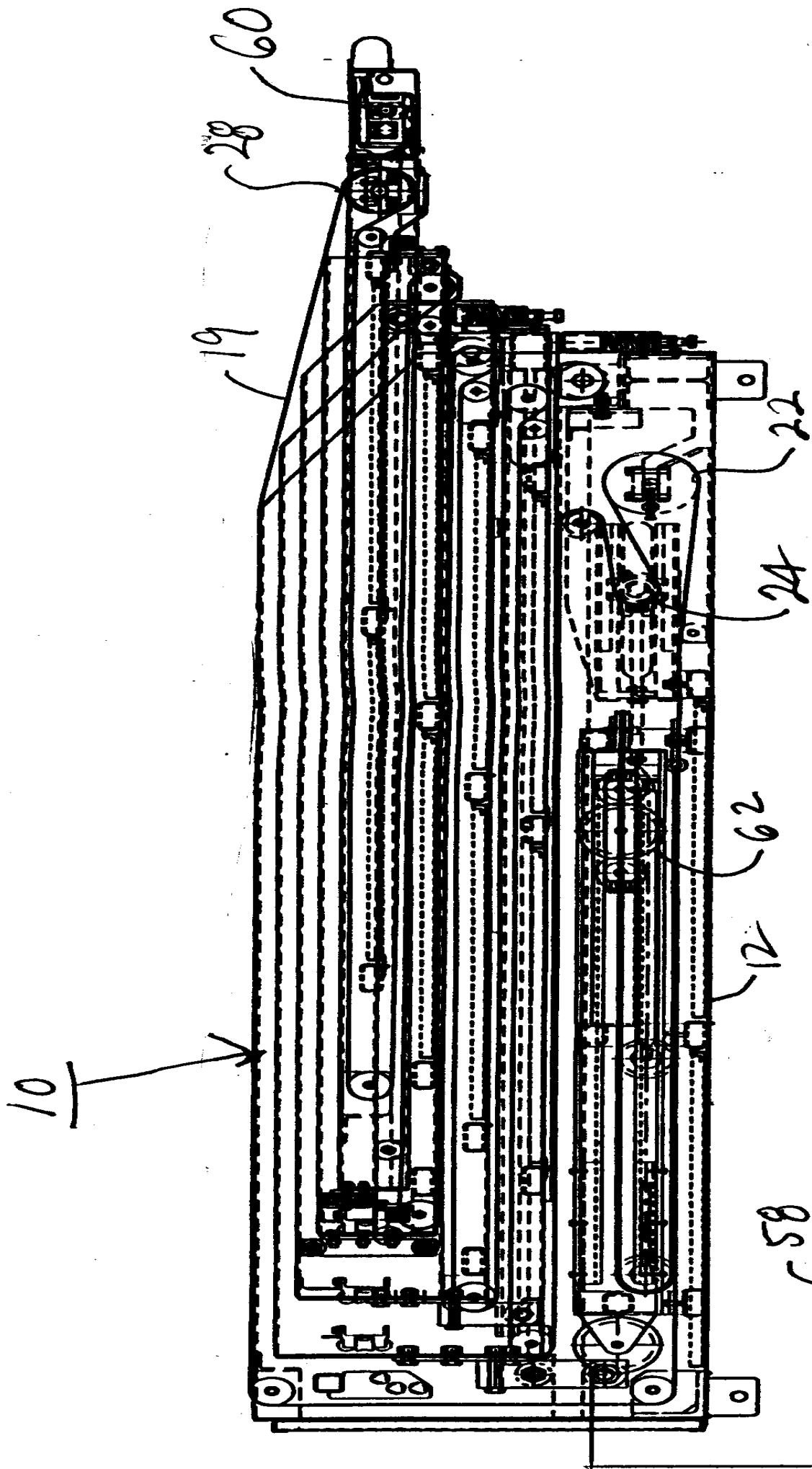


Fig 5

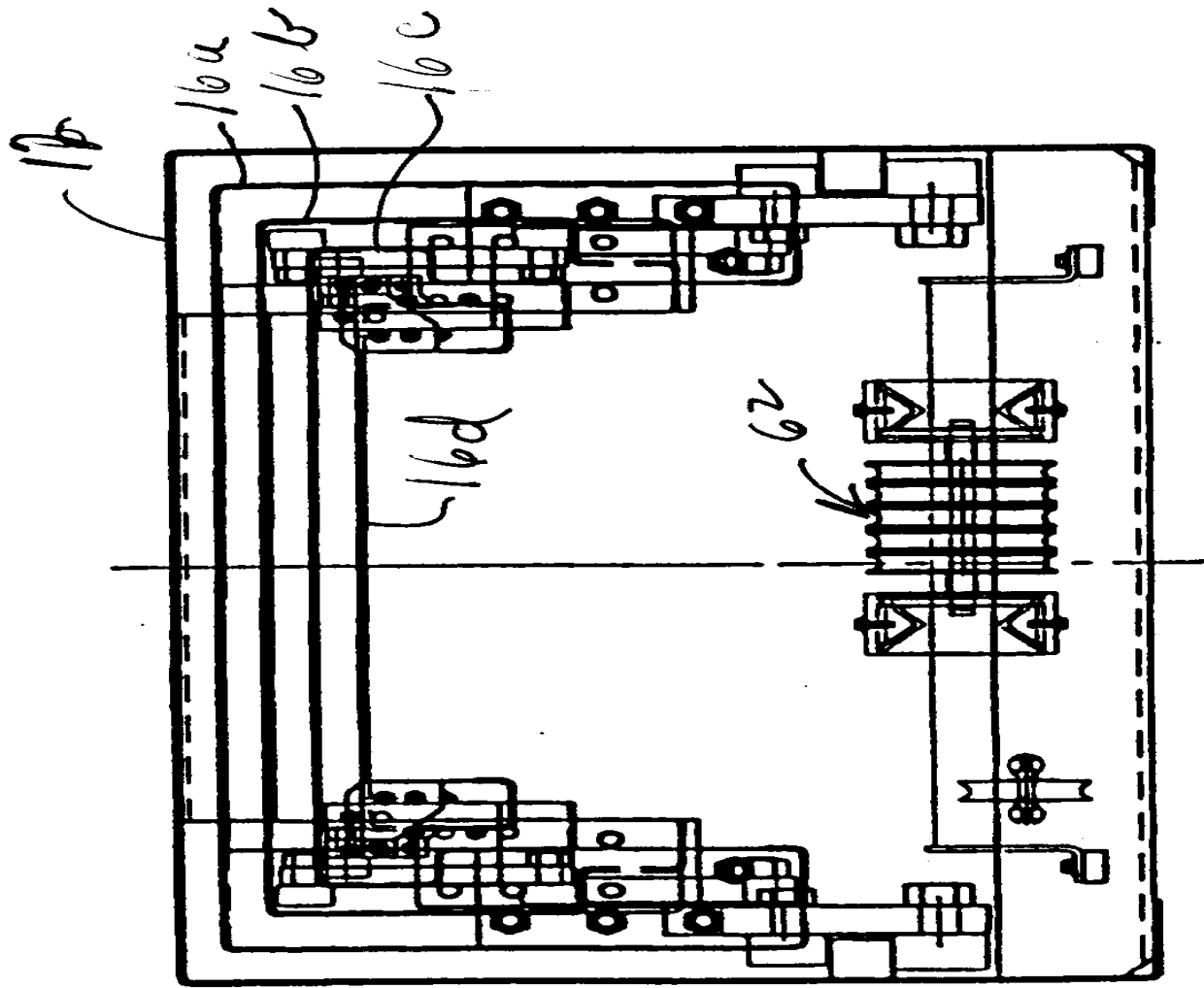


Fig. 6

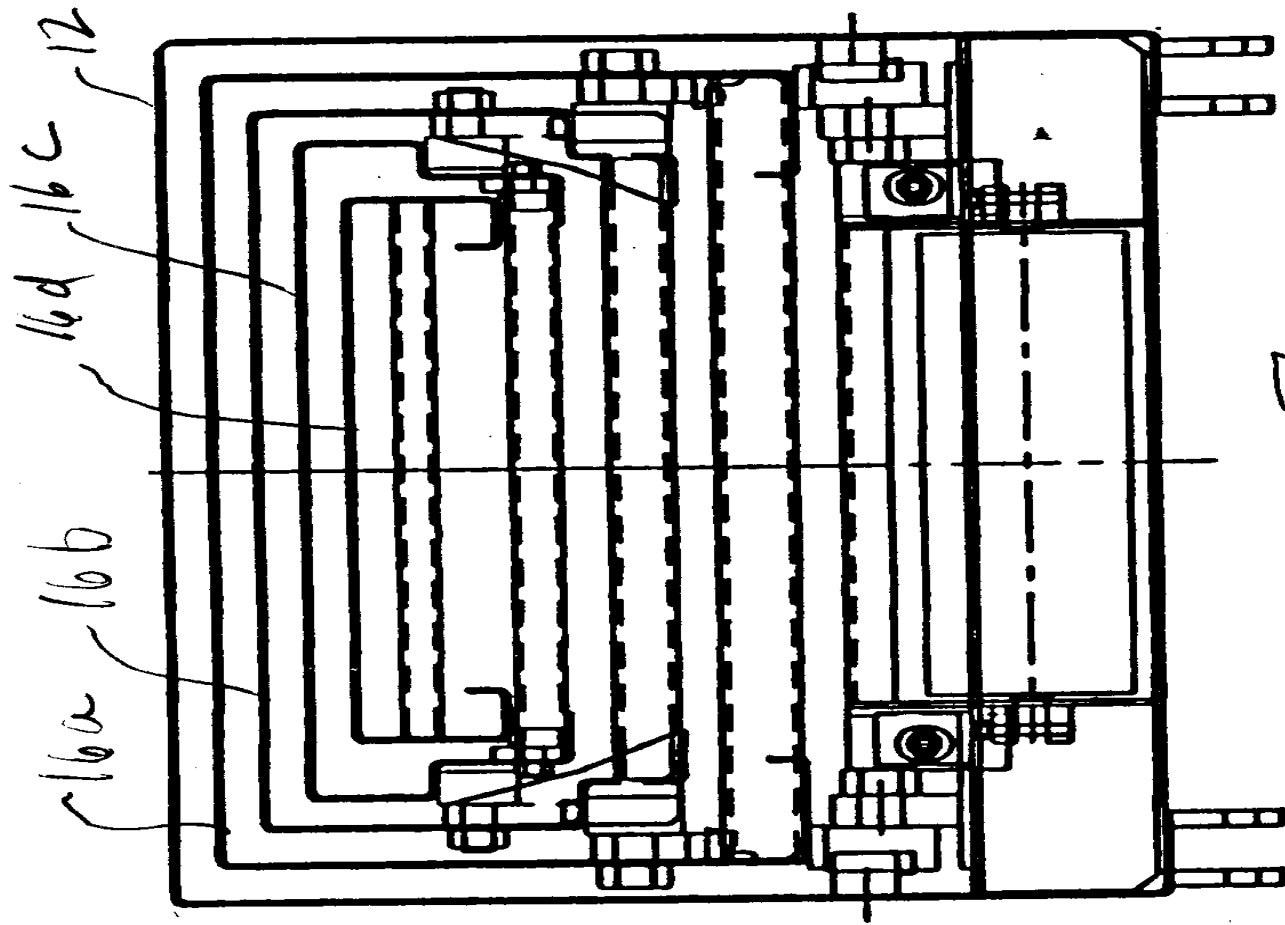


Fig. 7

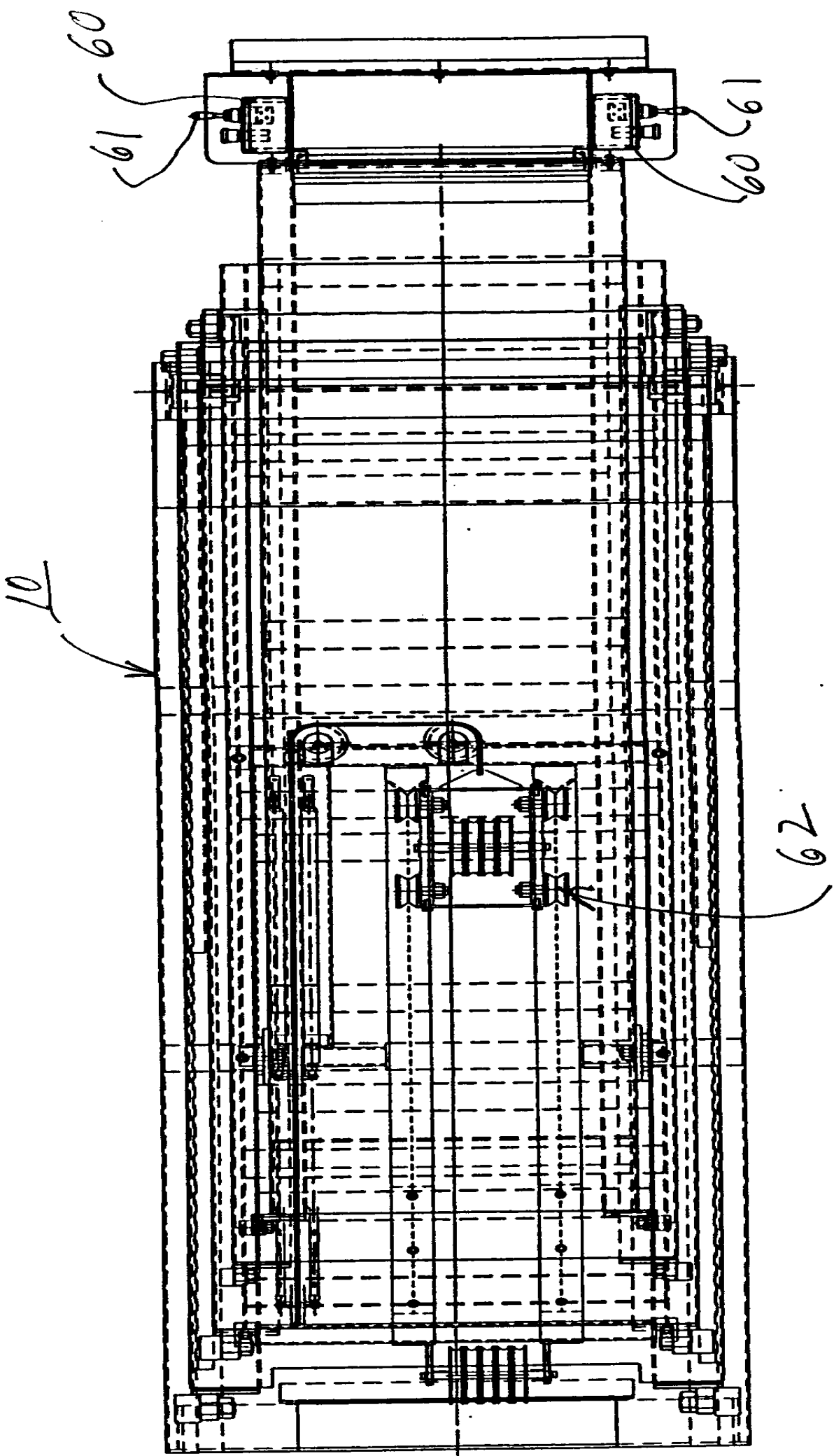


Fig 8

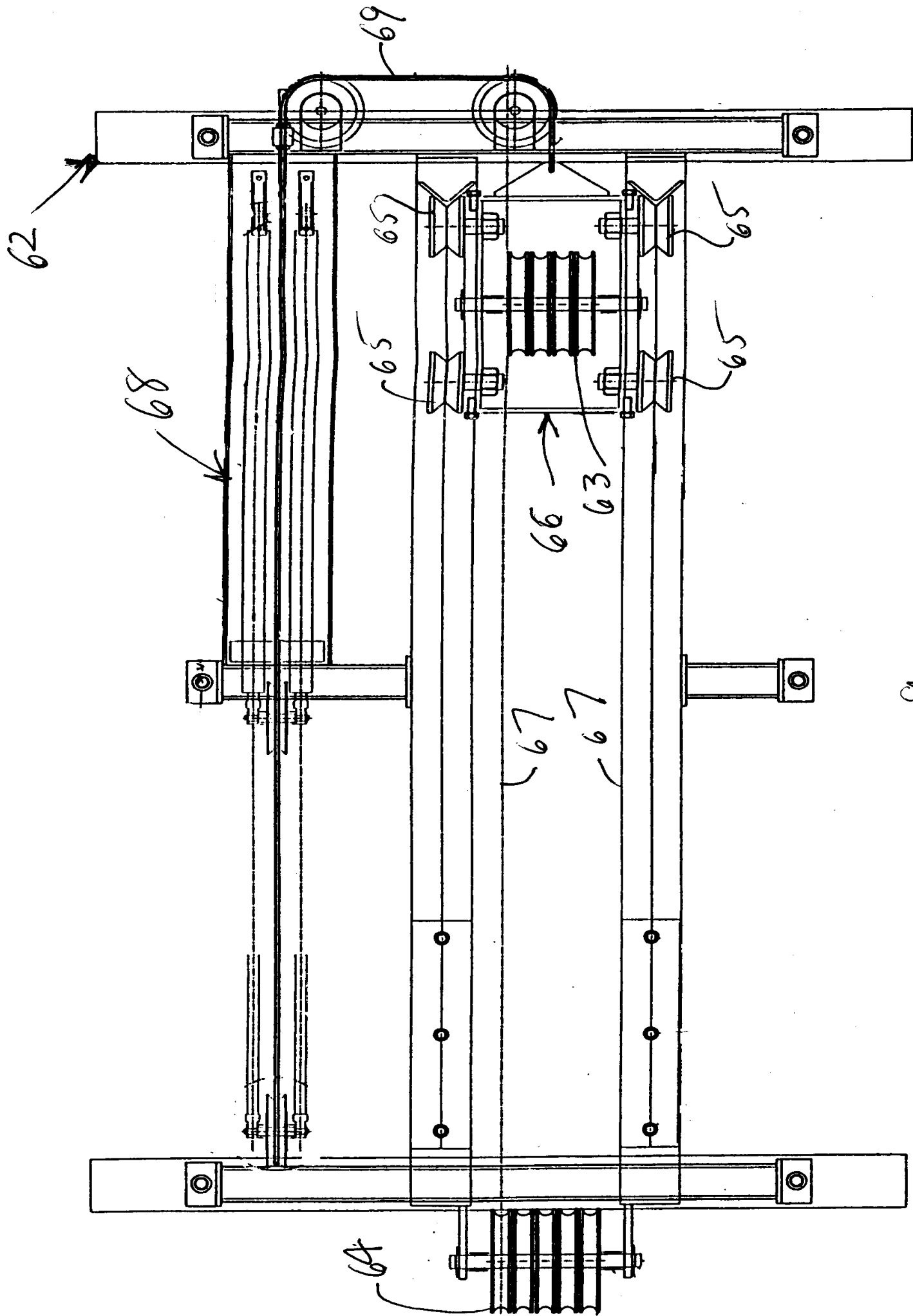


Fig 9

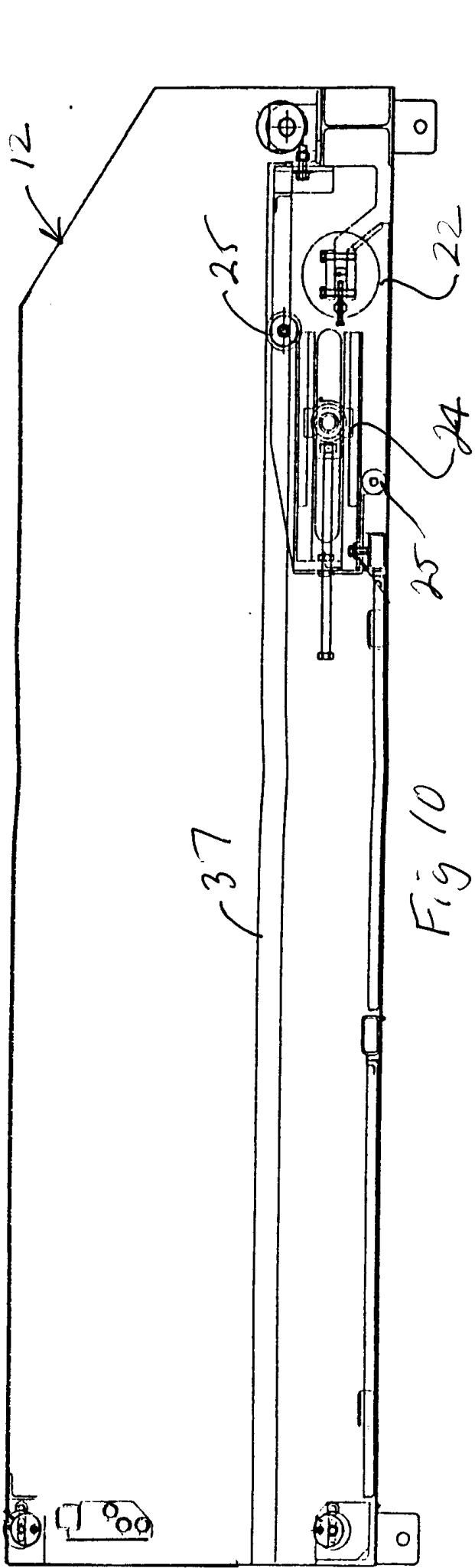


Fig 10

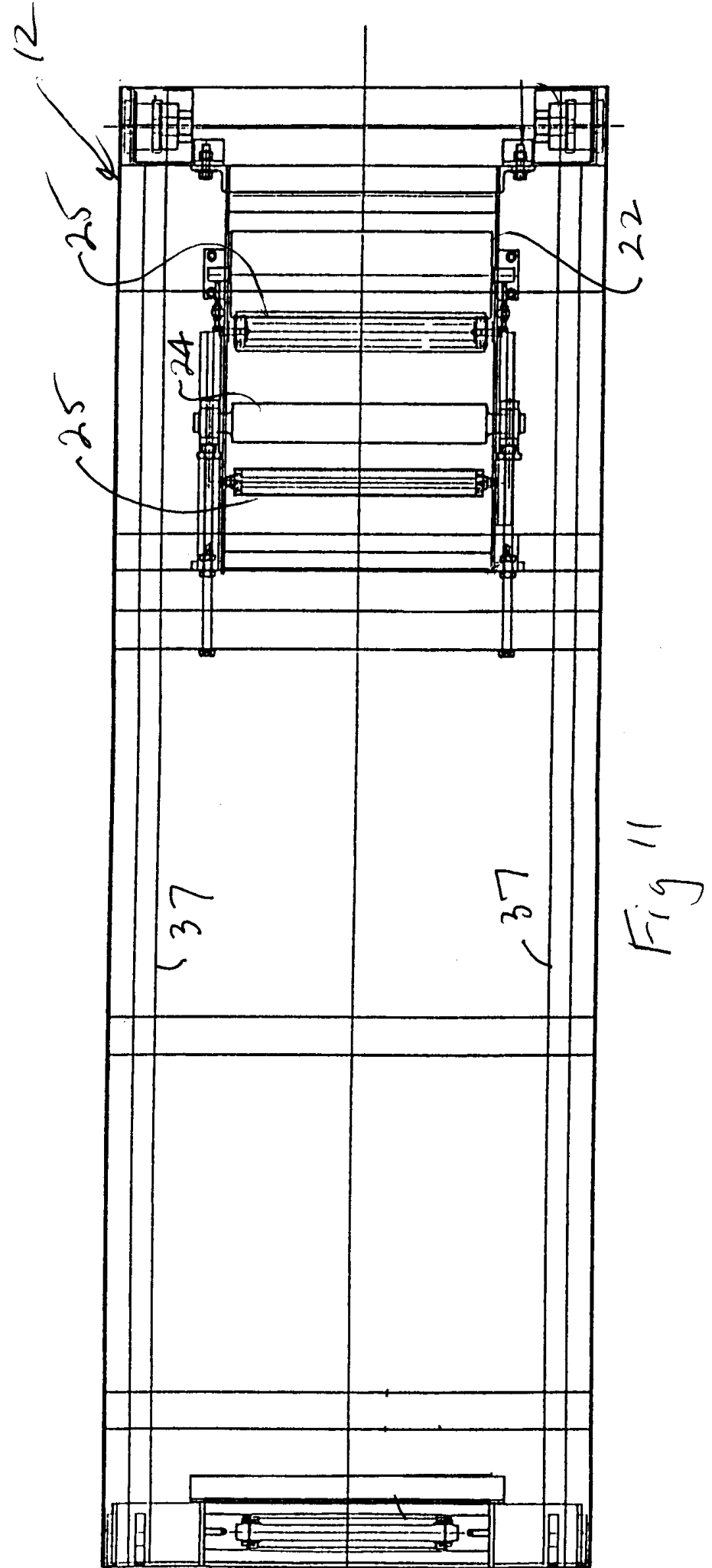
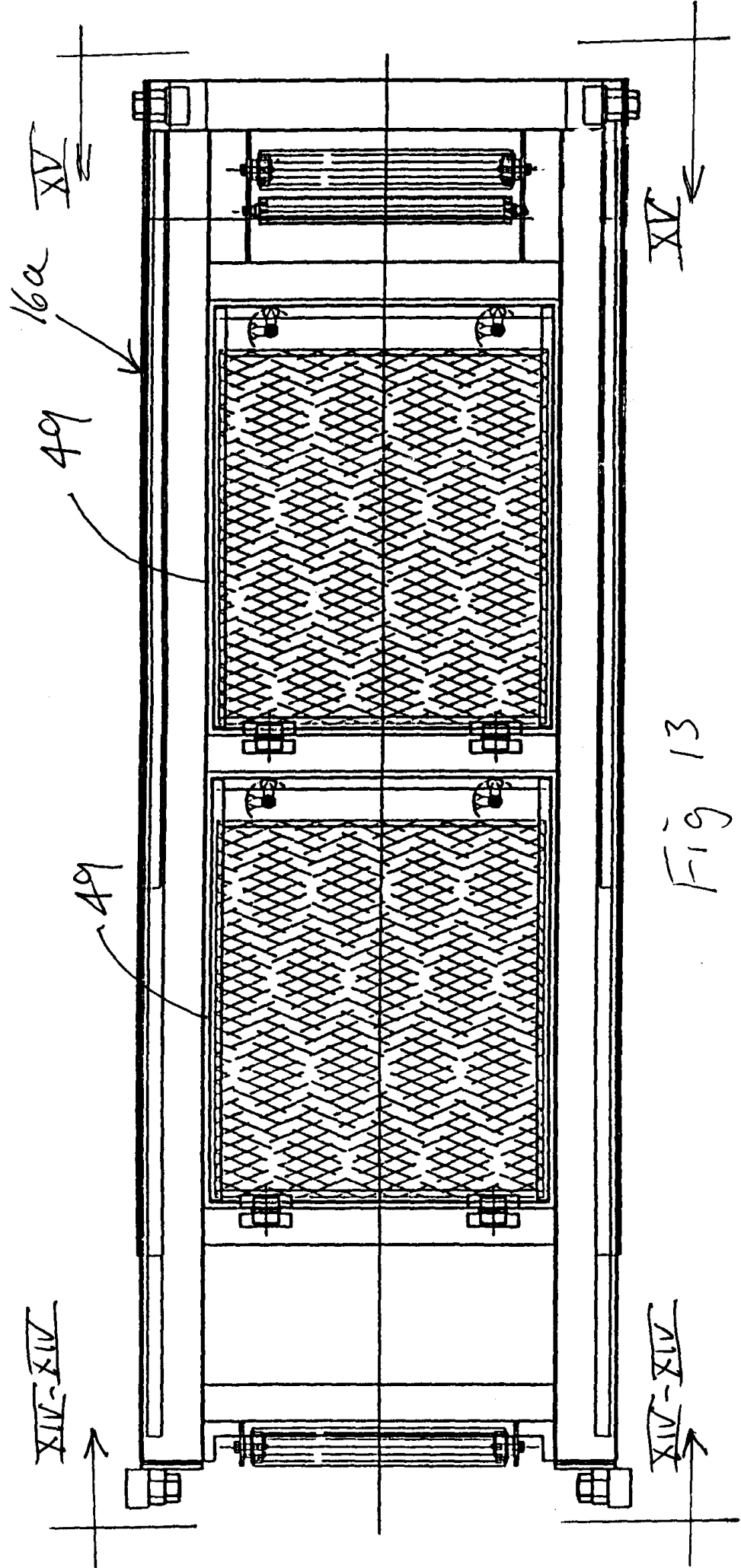
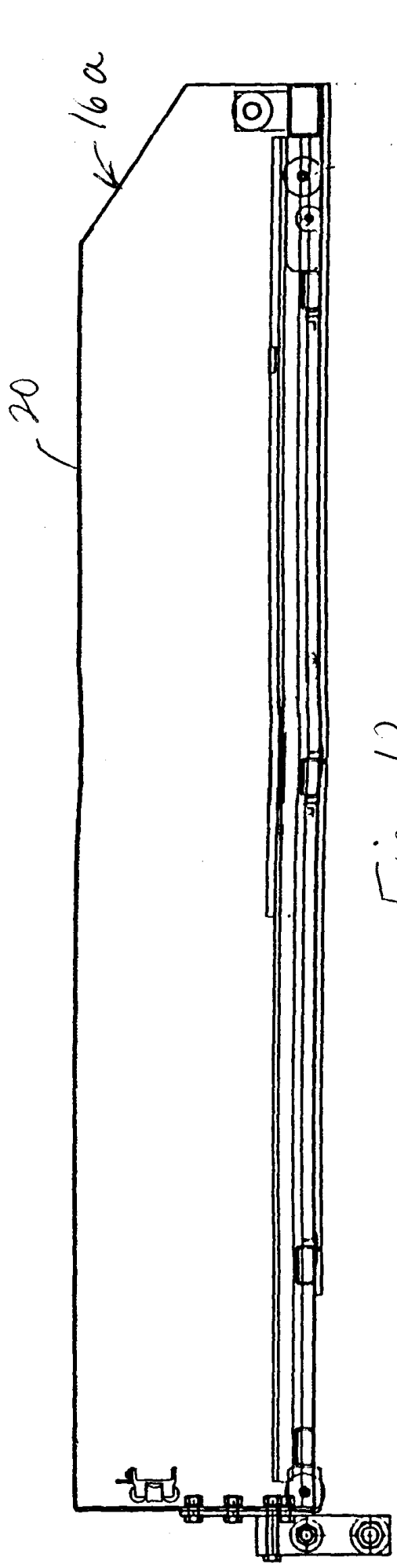


Fig 11





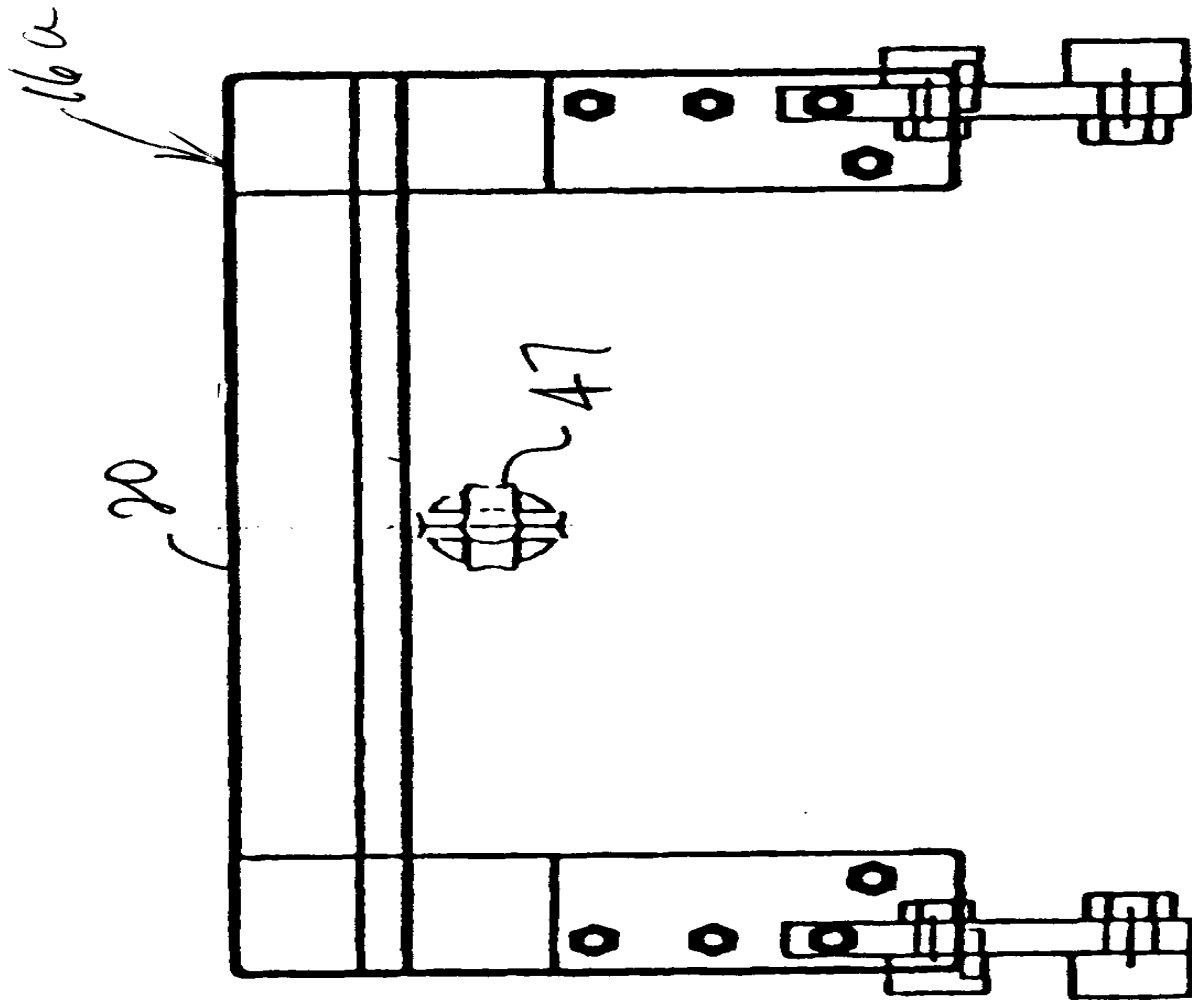


Fig 14

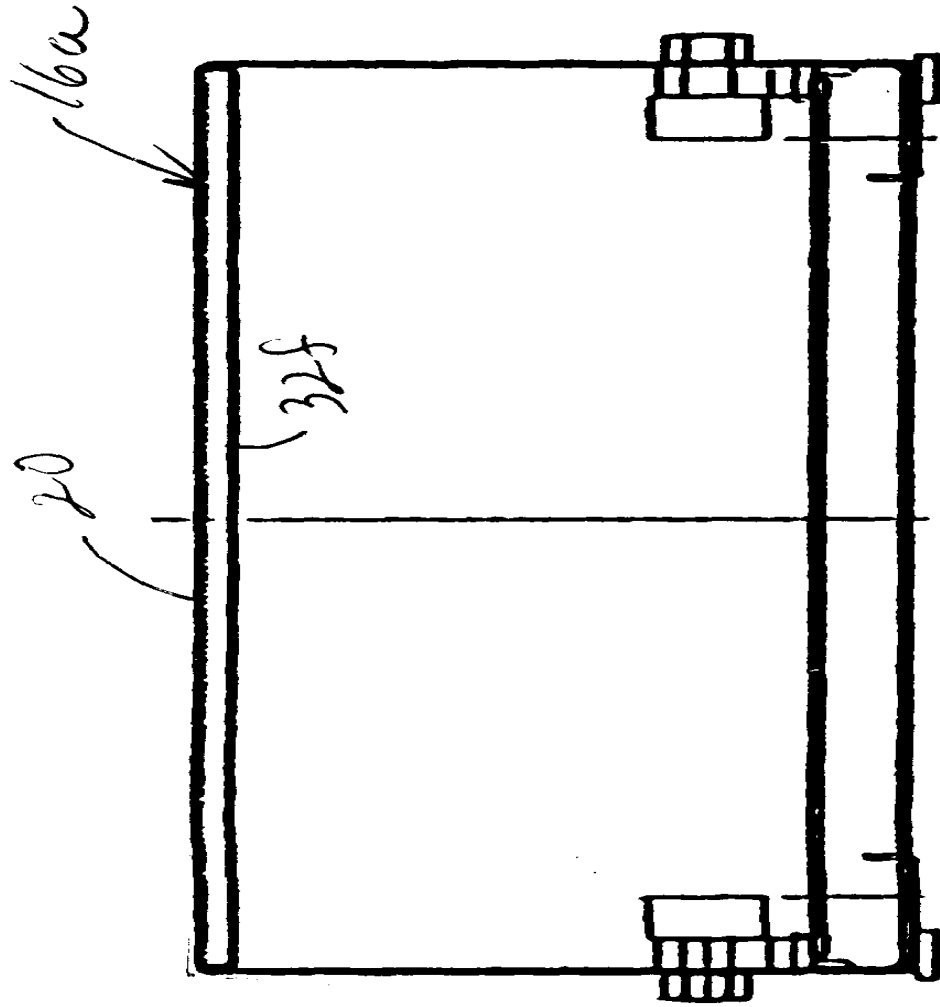


Fig 15

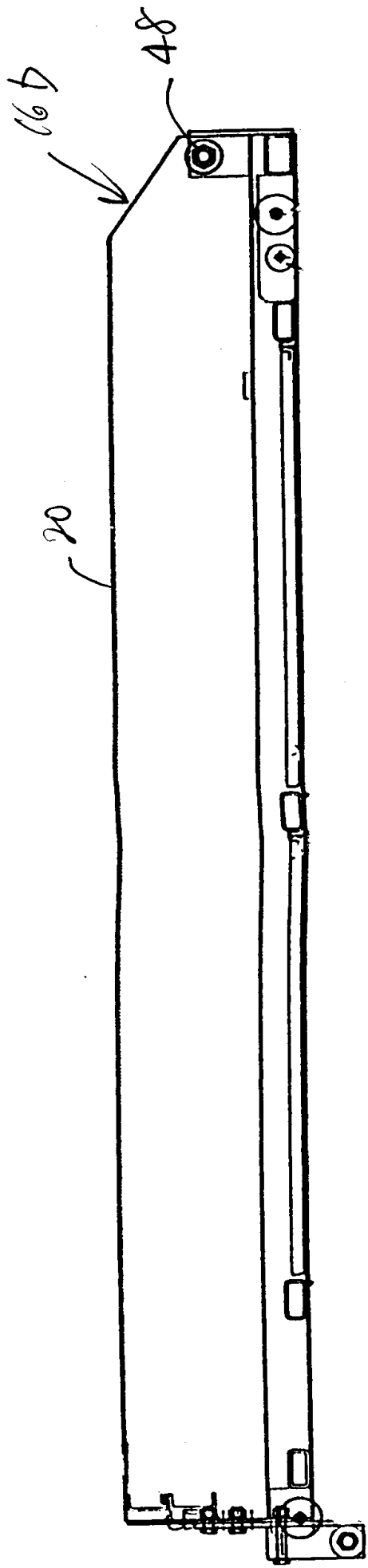


Fig 16

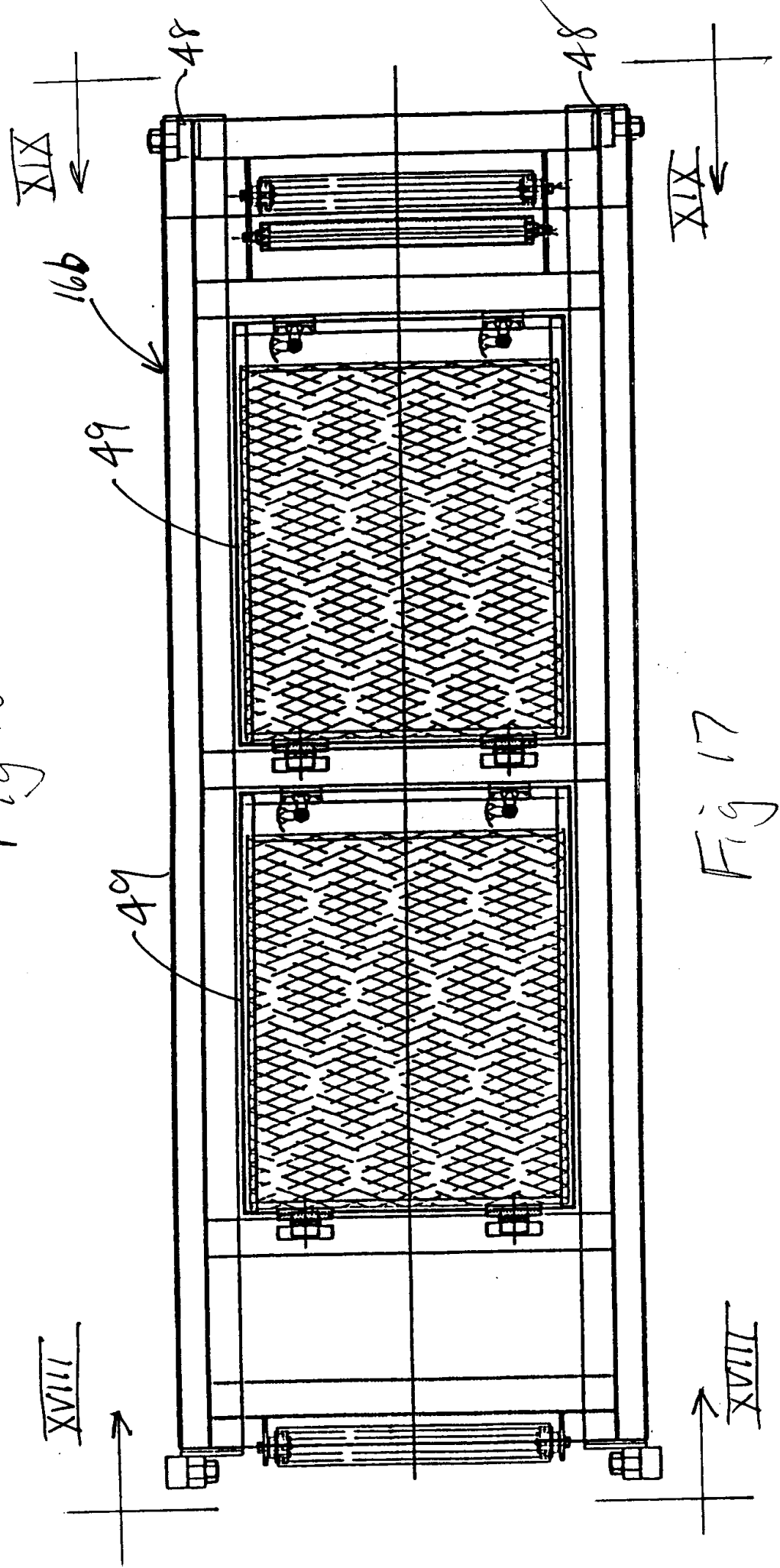


Fig 17

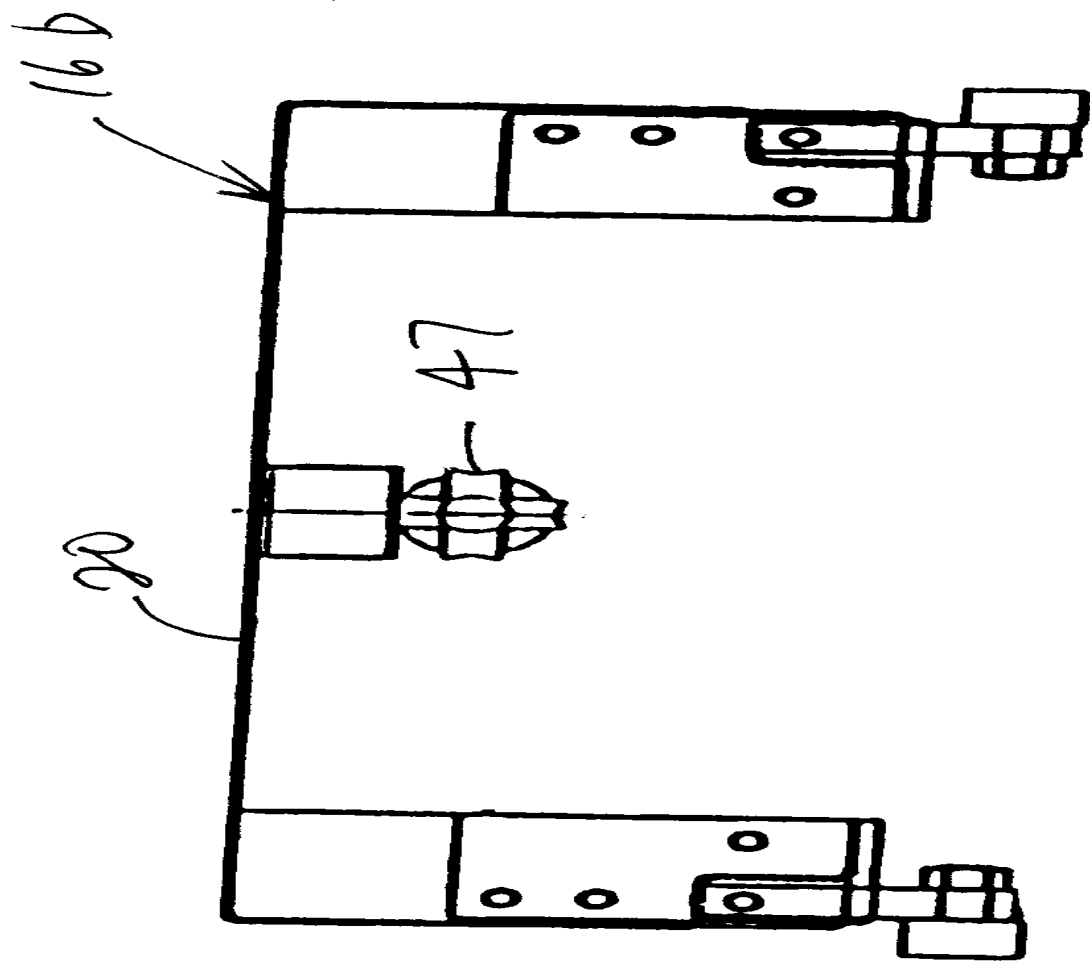


Fig 18

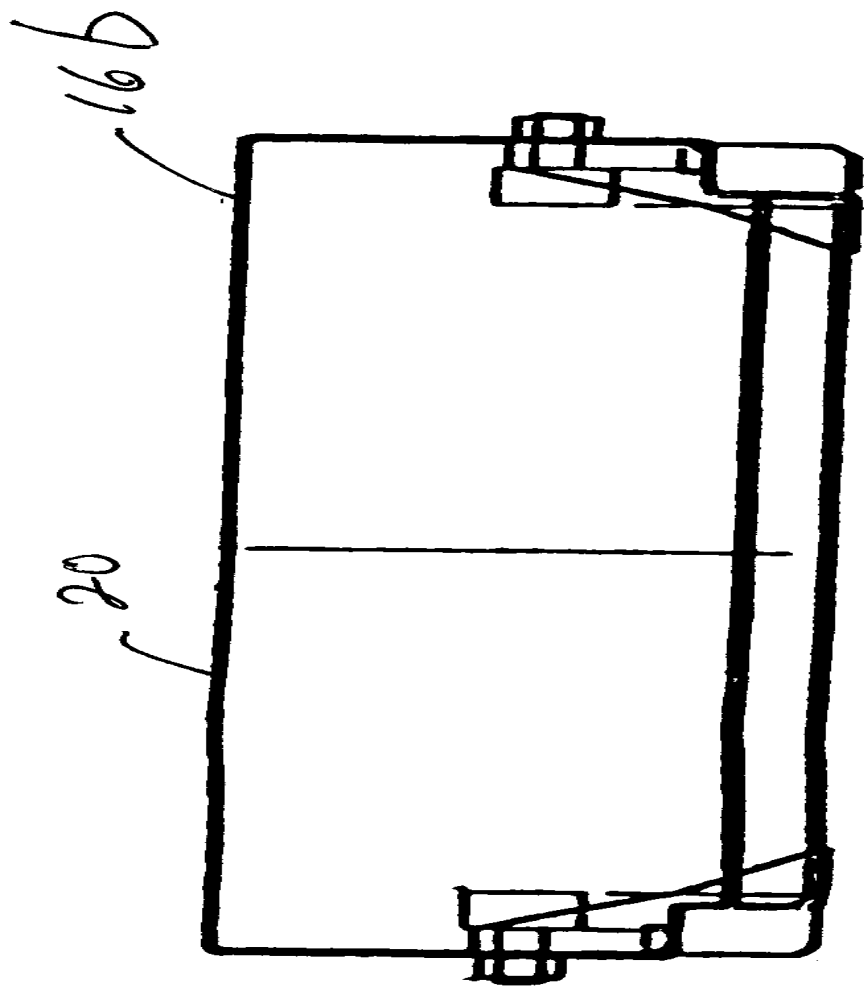


Fig 19

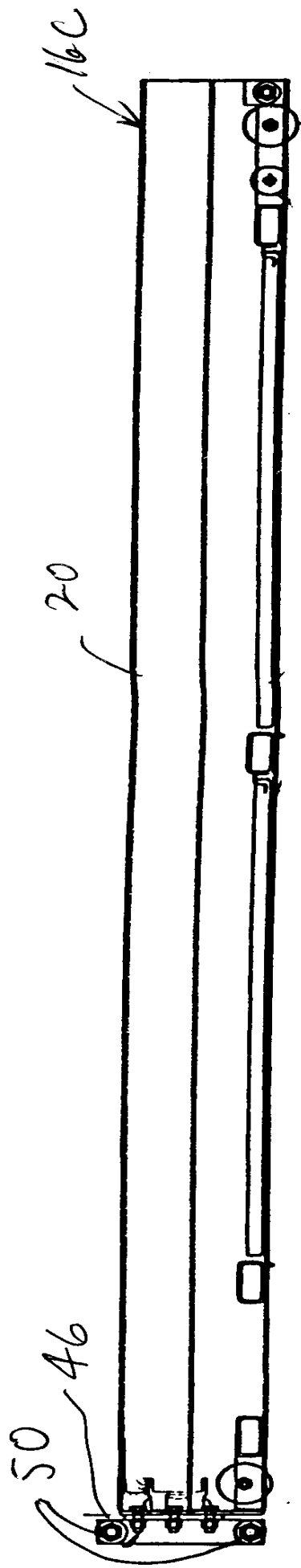


Fig 20

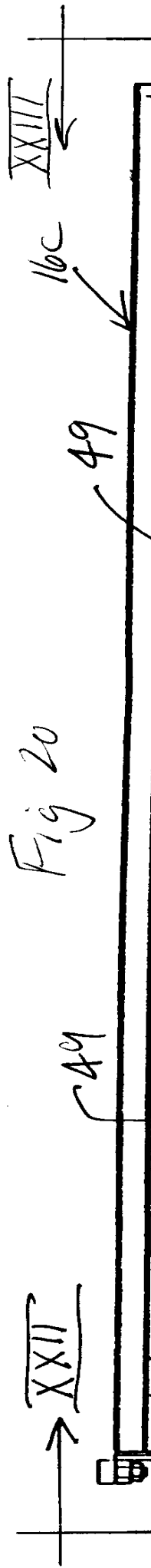


Fig 21



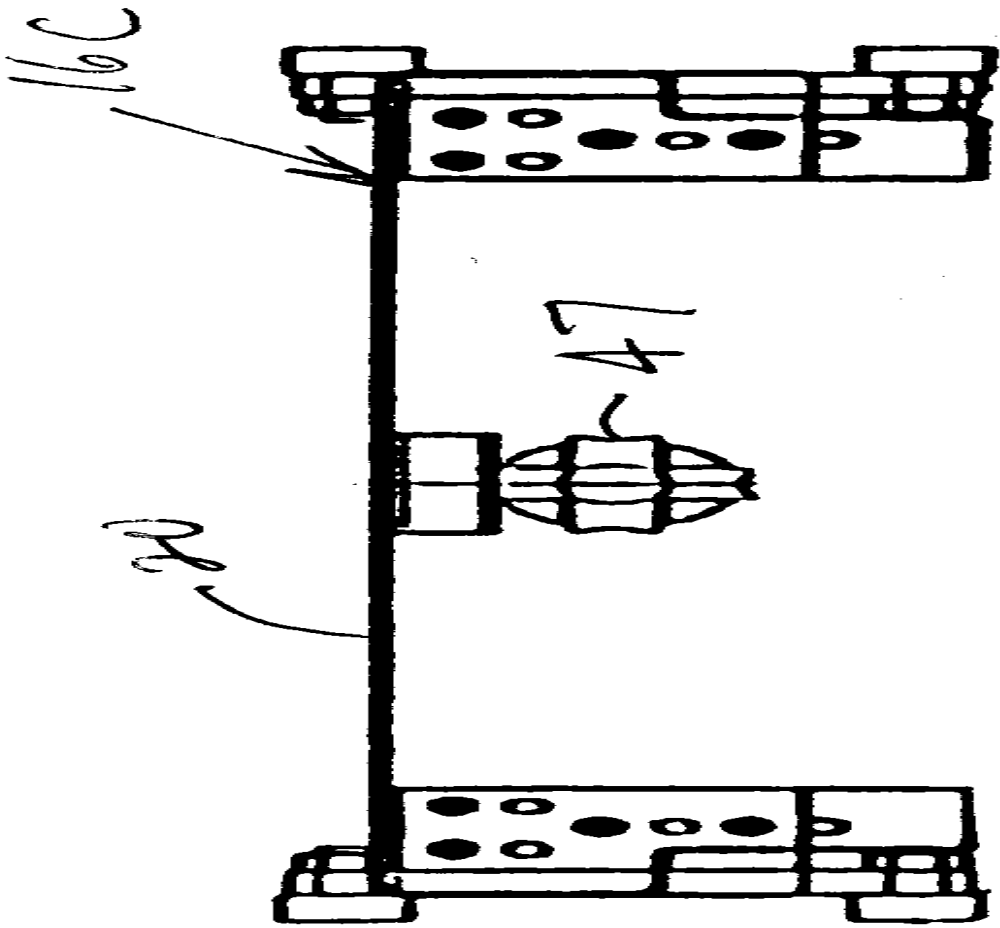


Fig 22

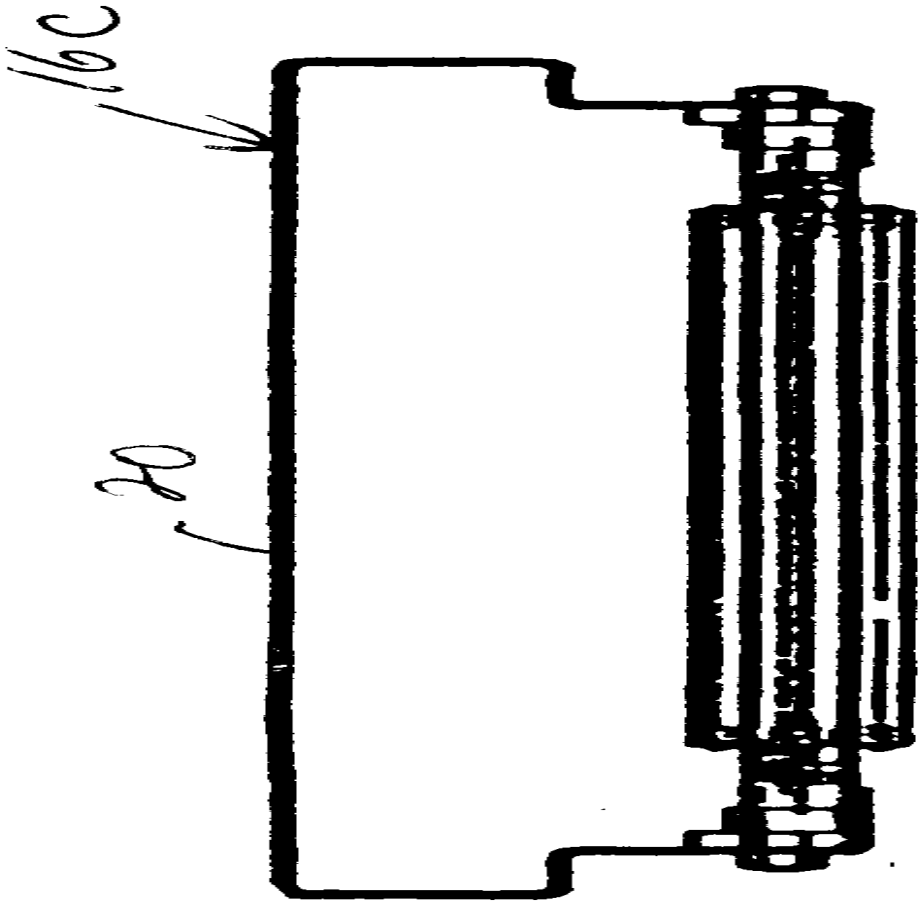


Fig 23

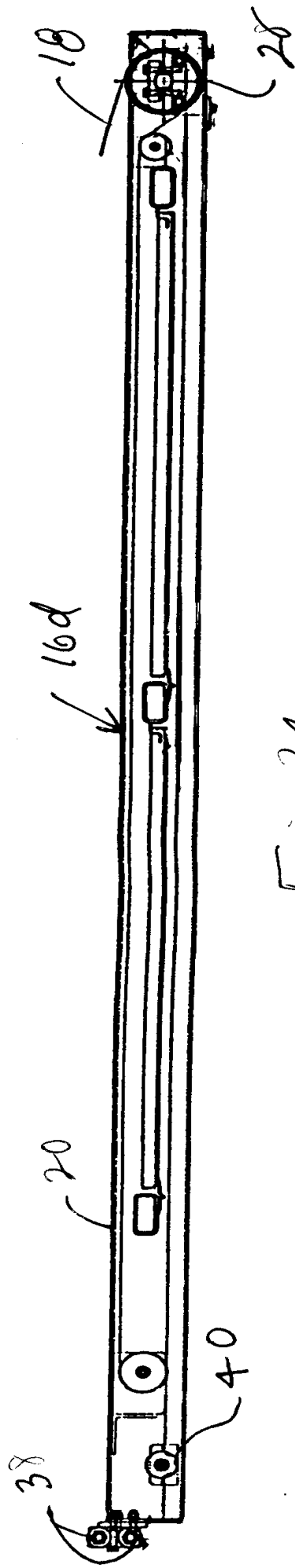


Fig 24

XXVI  
↑

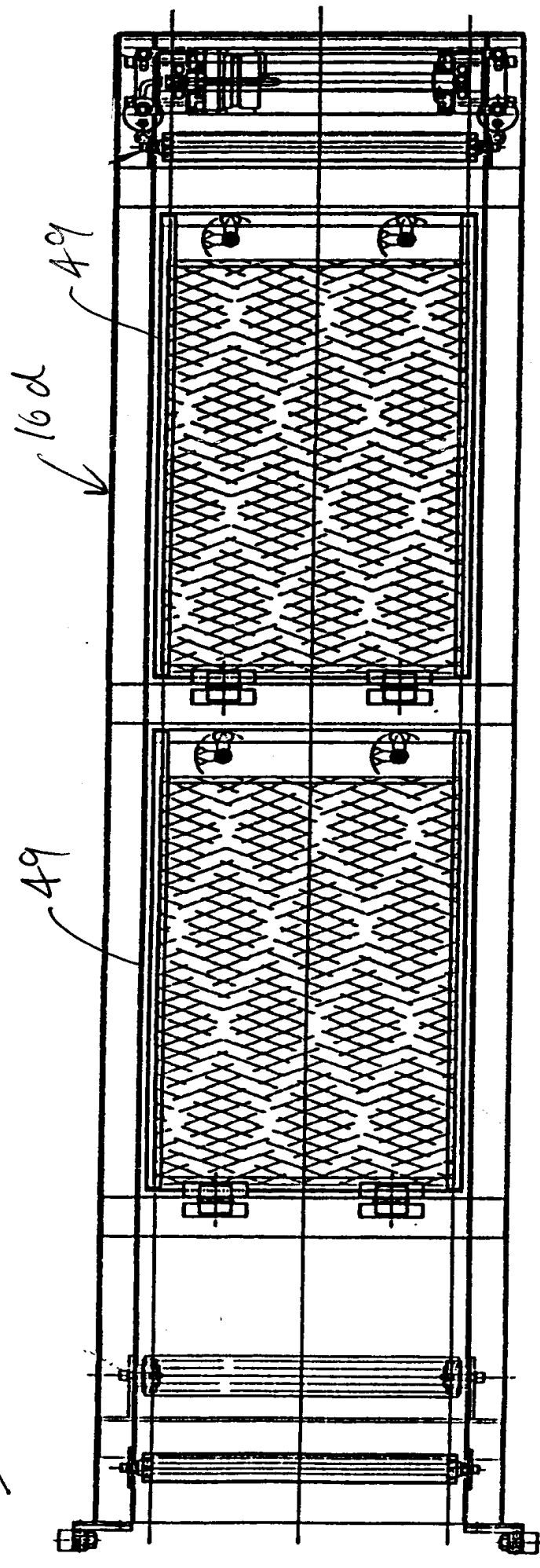


Fig 25

XXVII  
↑

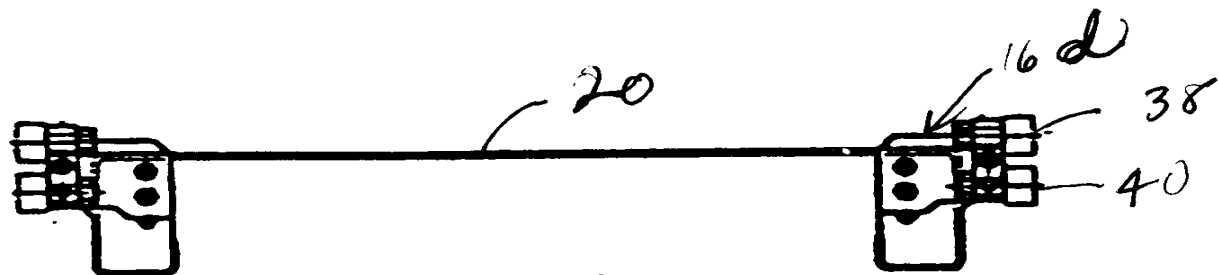


Fig 26

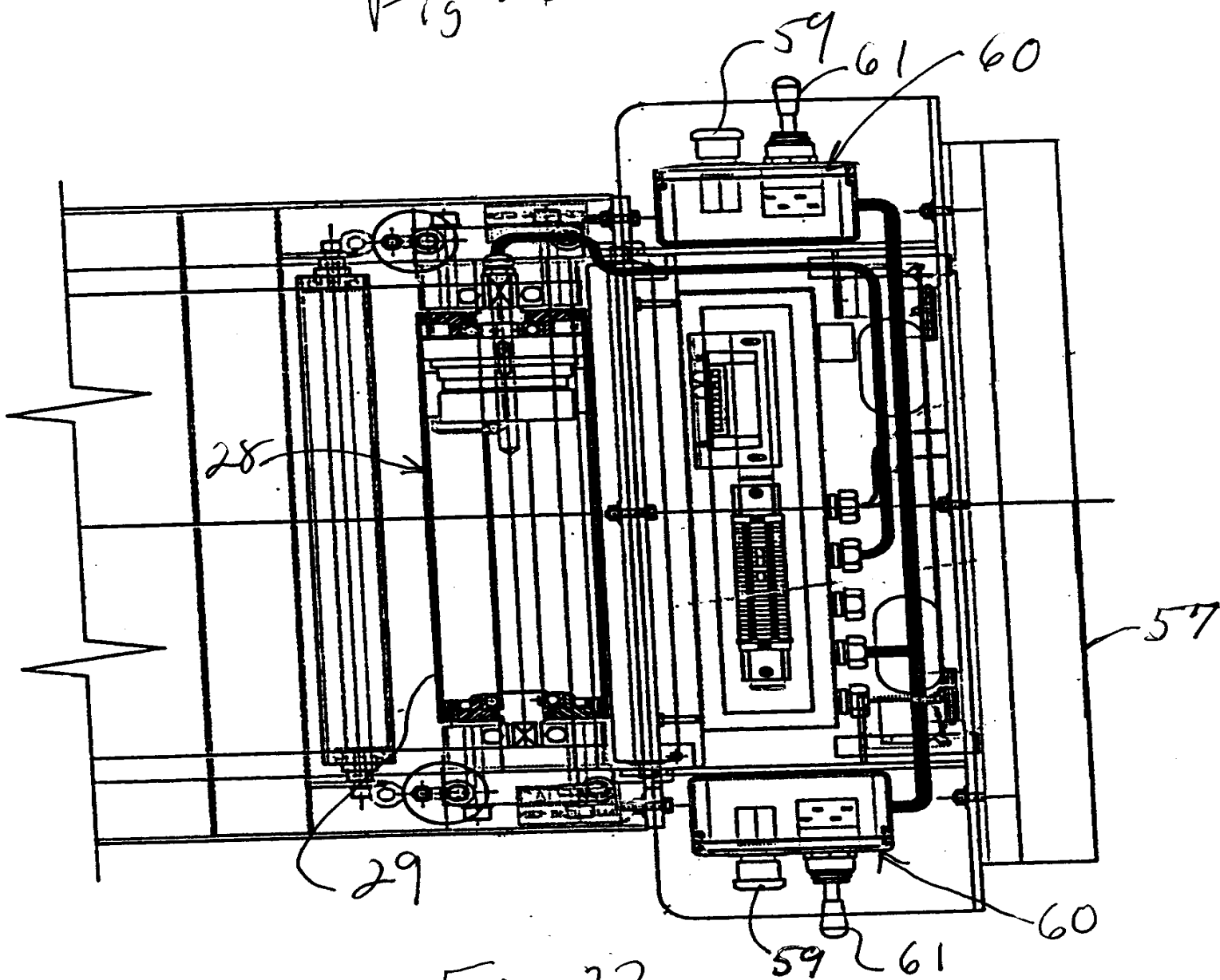


Fig 27

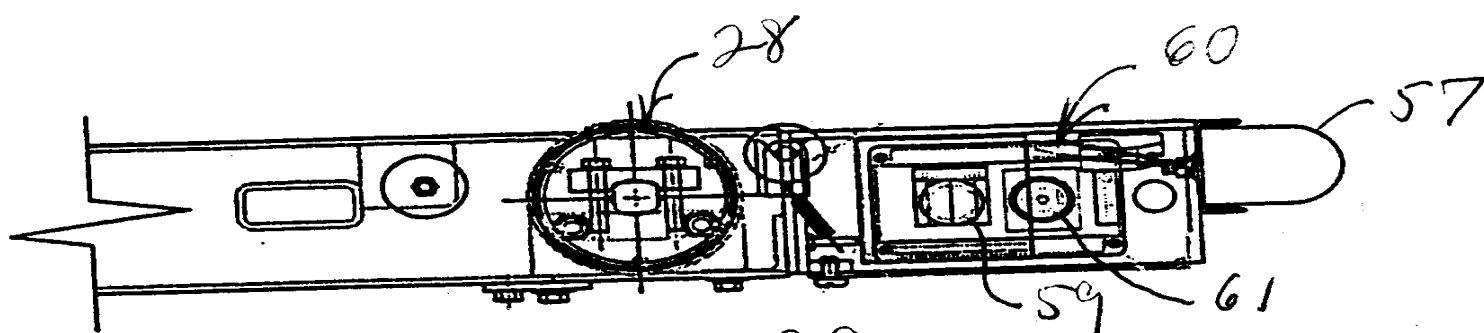


Fig 28



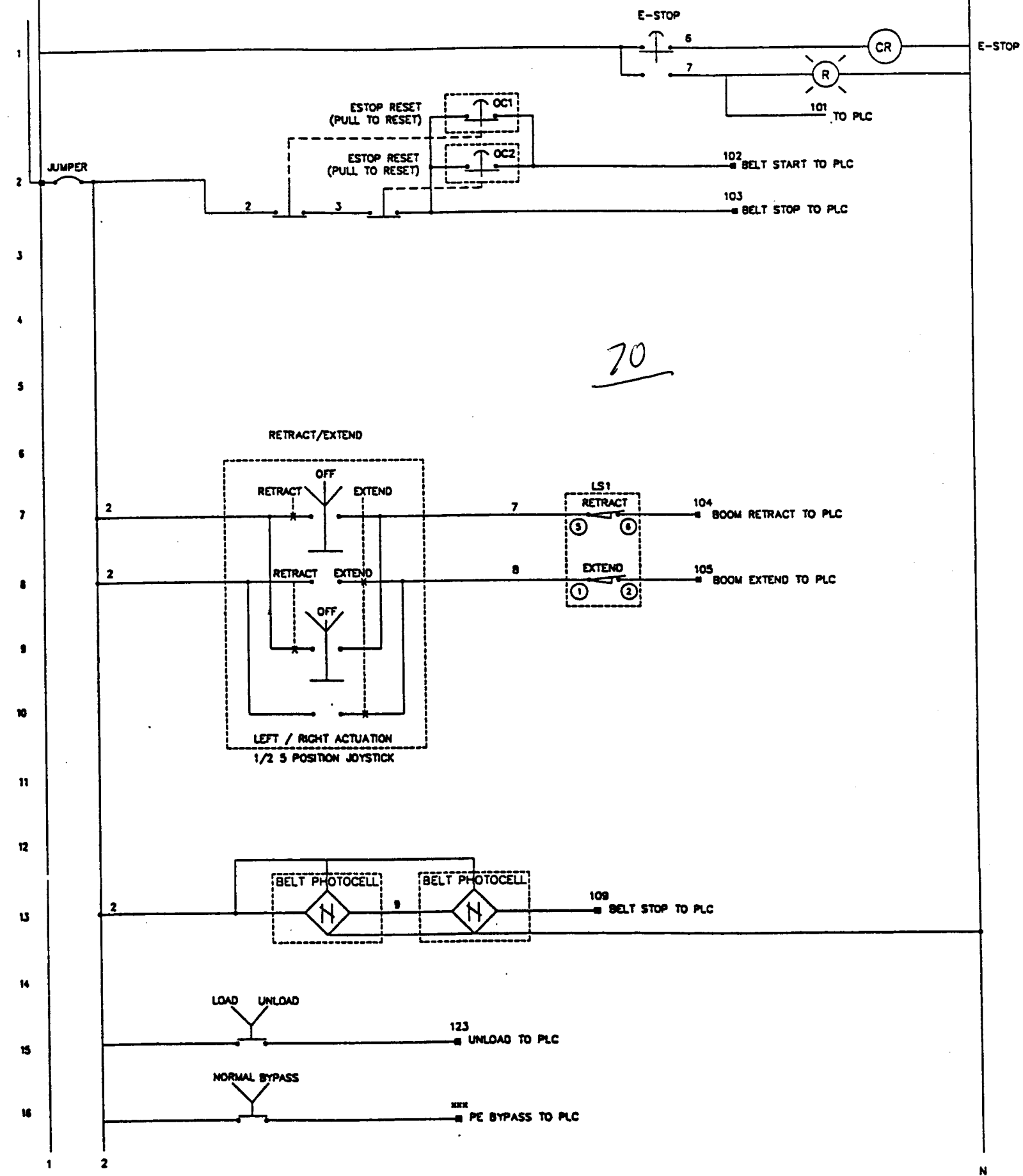
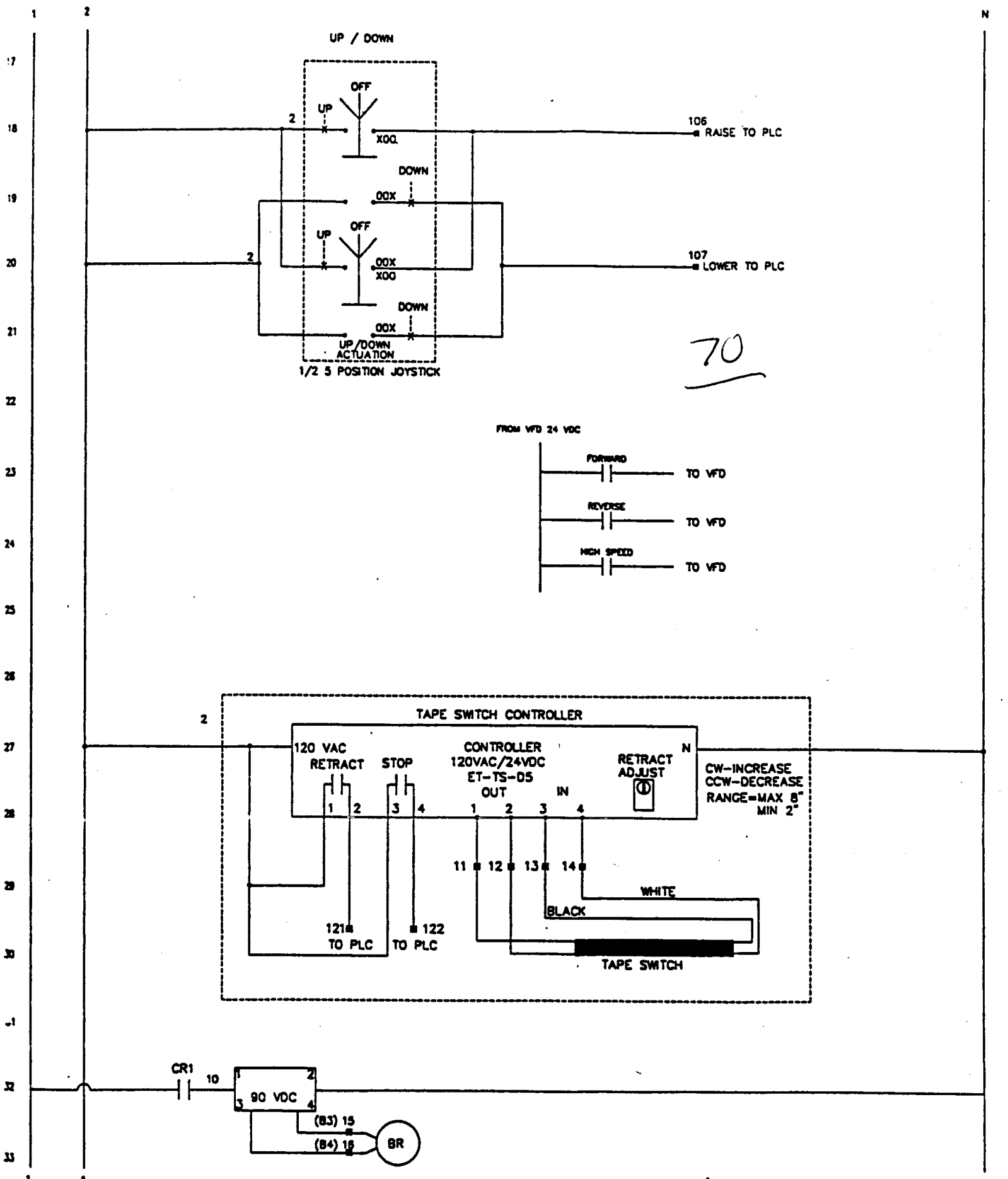


Fig 29a



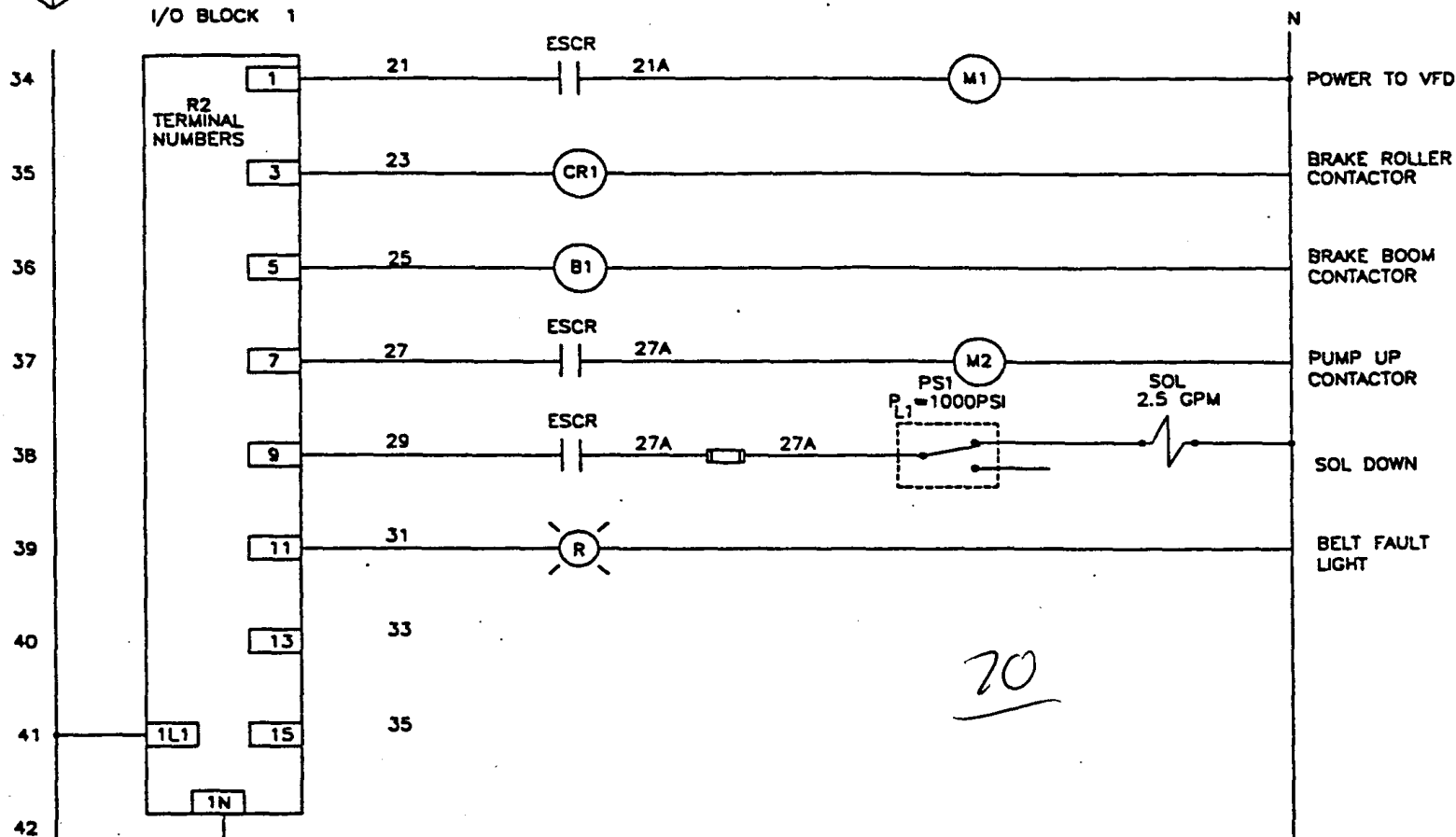
70

Fig 29 b

FROM 33  
↓

MODICON 120VAC  
OUTPUT MODULE  
170ADM69051  
I/O BLOCK 1

# PLC OUTPUTS



## I/O BLOCK 2

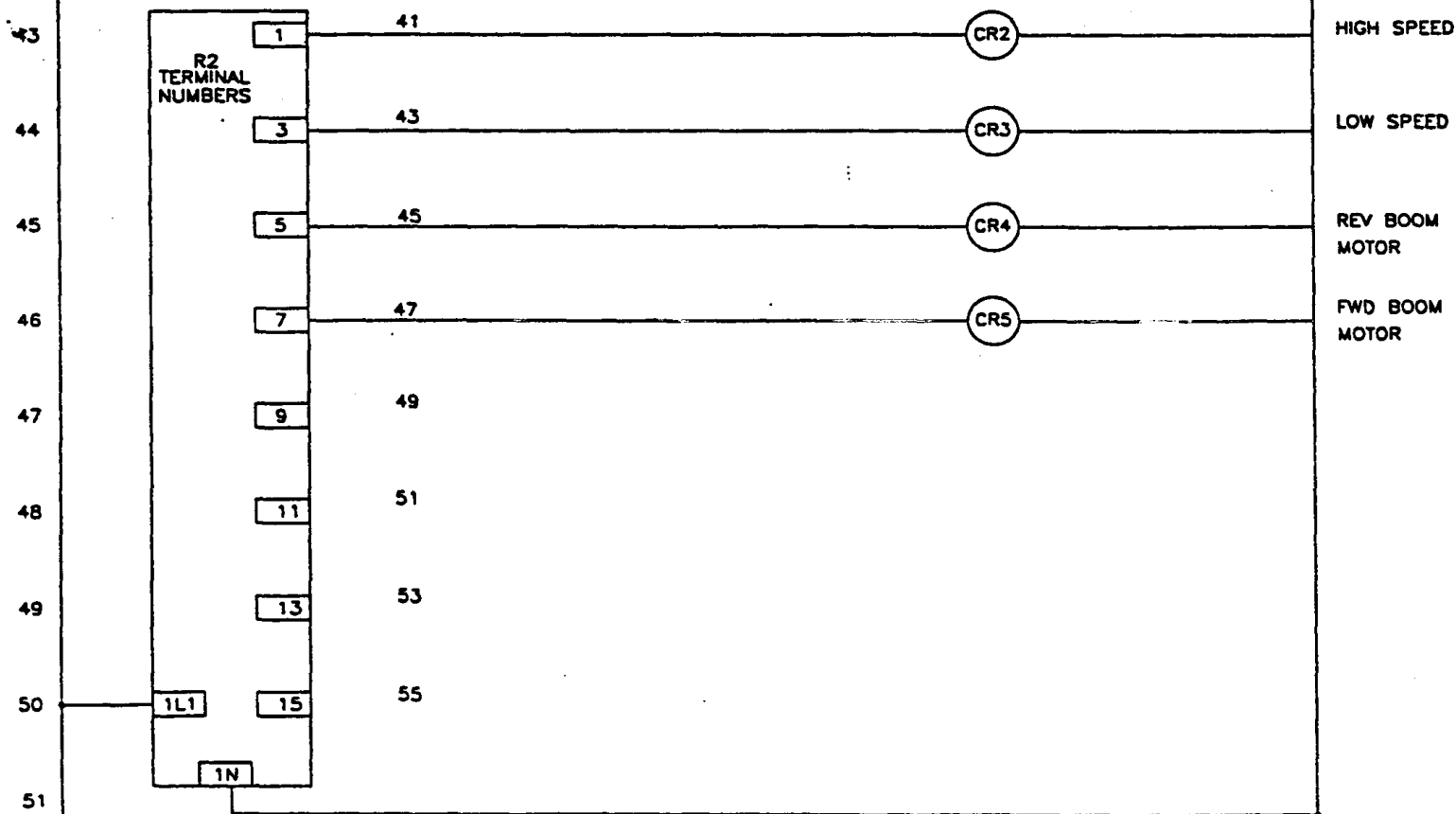


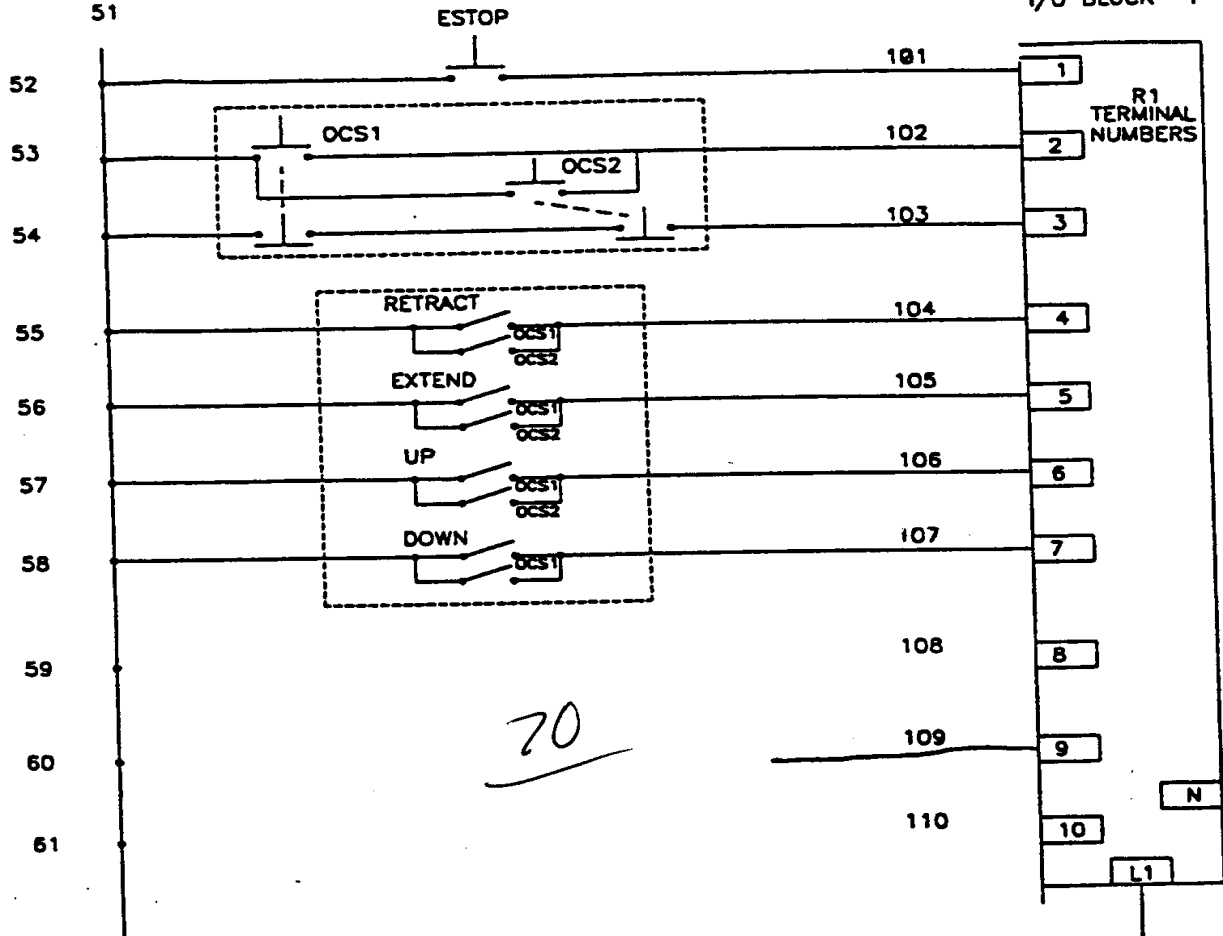
Fig 29c

FROM  
LINE 70  
51

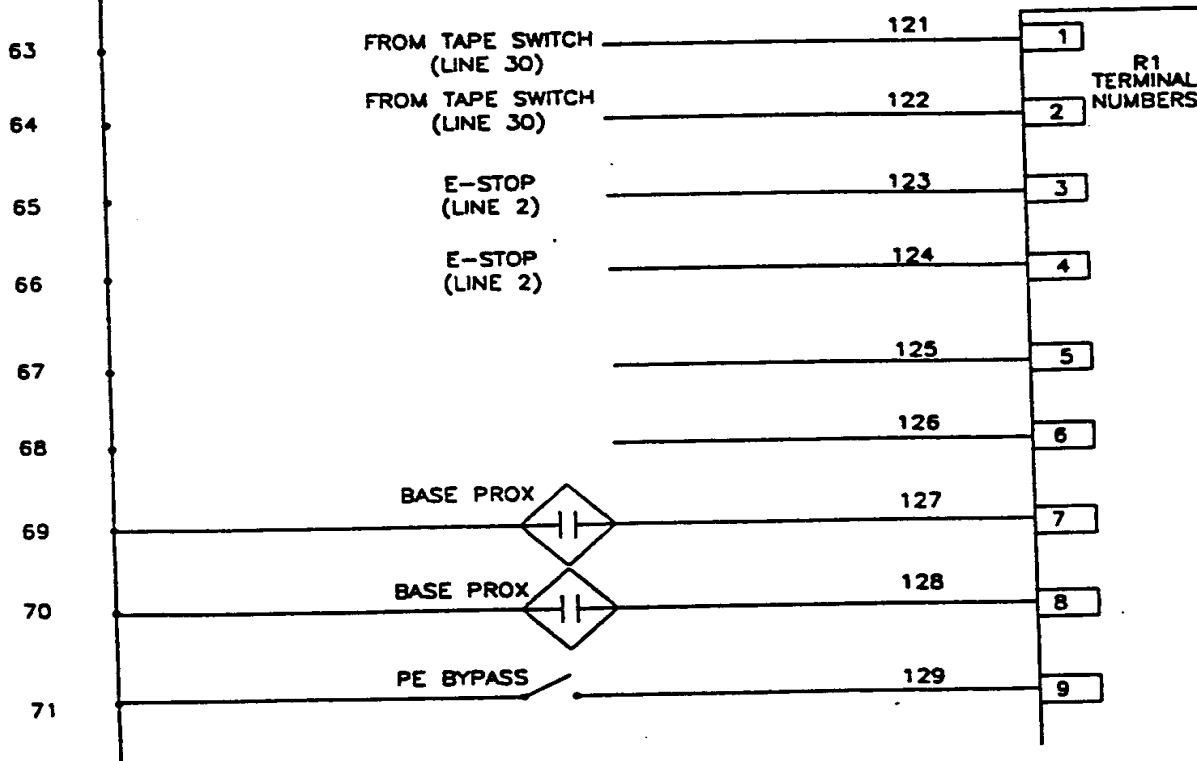
# PLC INPUTS

MODICON 120VAC  
INPUT MODULE  
170ADM69051  
I/O BLOCK 1

N



I/O BLOCK 2



E-STOP  
PUSHBUTTON  
BELT START  
PUSHBUTTON  
BELT STOP  
JOYSTICK RETRACT  
JOYSTICK EXTEND  
JOYSTICK UP  
JOYSTICK DOWN  
UP PROX  
BELT PE  
TAPE SWITCH  
RETRACT  
TAPE SWITCH  
STOP  
UNLOAD  
LOAD  
VFD FAULT  
PUMP OVERLOAD  
RETRACT PROX  
EXTEND PROX  
PE-BYPASS

Fig 29 d